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D3791-1
Job Sheet 192436



Part No: D3791-1

Job Qty: 12 ea

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3791 REV.B IPP Rev:A 08-05-13 new issue DD verified by:EC IPP Rev:B 08-05-22 revA as per dwg
ECN1191 DD verified by:EC IPP REV:C 18.11.09 AS PERR DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Waterjet - Flow - 1	12 pcs		4/19/19	0.26	0.98	Waterjet - Flow		
110	QC	12 pcs		4/19/19	0.00	0.00	QC2 Waterjet-2		
120	QC	12 pcs		4/19/19	0.00	0.00	QC8-3		
130	Brake NC	12 pcs		4/19/19	0.00	0.29	Brake NC 1		
140	QC	12 pcs		4/19/19	0.00	0.00	QC5		
150	Automated Welding - B4B	12 pcs		4/19/19	0.00	4.10	Automated Welding - 1 - B4B		
160	QC	12 pcs		4/19/19	0.00	0.00	QC10		
170	QC	12 pcs		4/19/19	0.00	0.00	QC5		
180	Spray Paint - 2 - B4B	12 pcs		4/19/19	0.00	0.21	Spray Paint - 1 - B4B		
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		
190	QC	12 pcs		4/19/19	0.00	0.00	QC3		
200	Packaging	12 pcs		4/19/19	0.00	0.00	Packaging3-1		
210	QC21-SA	12 Ea		4/19/19	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3791 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
Descriptions: 130 - 1-Deburr if necessary 2-Form on Brake as per Dwg D3791 using Jigs

140 - Ensure joggle as per dwg D3429

150 - ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____

180 - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI BATCH: _____

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	3.5004 sf (.2917 ea)	100-Waterjet - Flow - 1	S159674
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	4	311	0
Part Specifications				
Specifications could not be found.				

Plex 3/25/19 10:58 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



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Container No: S180555



Part: D3791-1

Job No: 194826

Serial No/Batch: S180555

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/13/19